



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.1610
Job Sheet 181383



Part No: 647.1610

Job Qty: 40 ea

Part Name: Wiper Deflector Fwd



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEET 2 IPP REV:A NEW ISSUE 12/11/01 JFS VERIFY BY: JLM IPP REV:B 13.09.03 now prime at ATG DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	9/10/18	9/10/18	0.00	0.00	Start Up Machining-1		2018-09-24
100	Bandsaw	40 pcs	9/10/18	9/10/18	0.00	0.04	Bandsaw1		2018-09-24
110	CNC Vertical Machining	40 pcs	9/10/18	9/10/18	0.00	67.62	HAAS1-1		2018-09-24
120	QC	40 pcs	9/10/18	9/10/18	0.00	0.00	QC2 Machining-1		2018-09-24
130	QC	40 pcs	9/10/18	9/10/18	0.00	0.00	QC8 Machining-1		2018-09-24
140	Outsource	40 pcs	9/10/18	9/10/18			ATG001-VC	5	SEP 25 2018
150	Packaging	40 pcs	9/10/18	9/10/18	0.00	0.00	Packaging2		OCT 23 2018
155	QC	40 pcs	9/10/18	9/10/18	0.00	0.00	QC5		38 DAS
180	Packaging	40 pcs	9/10/18	9/10/18	0.00	0.00	Packaging3-1		NOV 07 2018
190	QC21-SA	40 Ea	9/10/18	9/10/18	0.00	0.00	QC21		NOV 07 2018

Part Op 100 - Cut Blank at 6.750"

Descriptions: 110 - 1-Machine per folio FB143 DWG REV:_____ FOLIO REV:_____ 2- deburr and break all sharp edges

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Issue P/O to ATG : 8004133 1- Hard Anodize, Color Black and Prime as per Dwg, 647.1600

150 - Receive & Inspect for Damage & Mat'l Certs

155 - QC5- Inspect part completeness to step on W/O

180 - Identify as per dwg & Stock Location:_____ ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.750X2.250	7075-T6 Sheet 1.750" X 2.250"	22.5200 ft (.563 ea)	90-Start up Operation	5112 984

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S1.750X2.250	23	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

DART AEROSPACE LTD		Work Order:	181383
Description:		Part Number:	647-1610
Inspection Dwg:	647.1600	Rev:	
			Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	+/- 0.010	2.00	✓		KT-05 KHS	verm.
2.02	+/- 0.010	2.023	✓		3100G	H-G
R .20	+/- 0.010	.200	✓		R-G	
0.28	+/- 0.010	0.280	✓		KT-05	verm.
Ø.201	+0.005/-0.001	0.203	✓		" "	" "
Ø.406x.133 DP	+/- 0.005 x Ø.005	0.406x.132	✓		" "	" "
1.145	+/- 0.005	1.145	✓		" "	" "
0.94	+/- 0.010	0.940	✓		" "	" "
0.63	+/- 0.010	0.63	✓		" "	" "
3.85	+/- 0.010	3.85	✓		" "	" "
6.46	+/- 0.010	6.46	✓		" "	" "
136°	+/- 0.5°	136°	✓		CNC-17	A-6
1.20	+/- 0.010	1.200	✓		KT-05	" "
0.40	+/- 0.010	0.400	✓		" "	" "
0.86	+/- 0.010	0.860	✓		" "	" "
1.14	+/- 0.010	1.140	✓		" "	" "
4.77	+/- 0.010	4.77	✓		" "	" "
0.72	+/- 0.010	0.720	✓		" "	" "
0.44	+/- 0.010	0.44	✓		" "	" "
0.86	+/- 0.010	0.86	✓		" "	" "
Ø.500	+/- 0.010	0.500	✓			R-6
Ø.25	+/- 0.010	0.250	✓			" "
0.25	+/- 0.010	0.250	✓		3100G	H-6

Measured by:	KT 1	Checked by:	J.C.L.	QC Inspector:	
Date:	2018-09-22	Date:	18-09-25	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td style="width:25%;">Skid-tube ☐</td> <td style="width:25%;">Cross tube ☐</td> <td style="width:25%;">Water Jet ☐</td> <td style="width:25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																									
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Dart Aerospace Ltd. 1270 Aberdeen Street Hewkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 09/24/18 Container No: S112992 Part: 647.1610 Job No: 181383 Serial No/Batch: S112992 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____		Completed By _____																																																										
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041133**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

PO No: PO041133
PO Date: 9/25/18
Due Date: 10/18/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Attention: Lalonde, Marc-Andre

Via: Ground
Pymt Terms: Net 30

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178993	RBE350A94-3700-C-07	Top -Issue P/O to ATG: PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A94- 3700-C-07 Rev 6 -Certificate of Conformity is required	Firmed	-	10/18/18	40 pcs	0 pcs	40 pcs	\$4.55/pcs	\$182.00
2	181383	647.1610	Wiper Deflector Fwd Issue P/O to ATG : 1- Hard Anodize, Color Black and Prime as per Dwg, 647.1600	Firmed	-	10/18/18	40 pcs	0 pcs	40 pcs	\$11.50/pcs	\$460.00
3	182779	D5575-1	Deflector, Lower Cable Cutter : Various STC's Issue P/O to ATG : Black Anodize & Prime as per Dwg. D5575-1 Certification of Conformity is required.	Firmed	-	10/18/18	2 pcs	0 pcs	2 pcs	\$9.30/pcs	\$18.60

DAS
38
9-89



Dart Aerospace Ltd.
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K6A 1K7
Canada

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PURCHASE ORDER **PO041133**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	181917	644.4112	Spacer 1-ISSUE P/O TO ATG: 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil-A- 8625 Type 3 Class 2 3-Certification of Conformity is required	Firmed	-	10/18/18	30 pcs	0 pcs	30 pcs	\$5.75/pcs	\$172.50
							30 X OCT 03 2018				
5	181392	647.7612	Breakaway Tip Issue P/O to ATG : Hard Anodize, Color Black and Prime as Per Dwg 647.7600	Firmed	-	10/18/18	50 pcs	0 pcs	50 pcs	\$11.50/pcs	\$575.00
							50 X OCT 17 2018				
6	182775	D5576-1	Deflector, Upper, Cable Cutter : Various STC's Issue P/O to ATG : Black Anodize & Prime as per Dwg. D5576 Certification of Conformity is required.	Firmed	-	10/18/18	2 pcs	0 pcs	2 pcs	\$10.30/pcs	\$20.60
							2 X OCT 10 2018				
7	181920	644.4120	Spacer, Crosstube 1-ISSUE P/O TO ATG: 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil-A- 8625 Type 3 Class 2 3-Certification of Conformity is required	Firmed	-	10/18/18	30 pcs	0 pcs	30 pcs	\$5.75/pcs	\$172.50
							30 X OCT 03 2018				
Grand Total:											\$1,601.20



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PURCHASE ORDER
PO041133

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/26/18 2:16 PM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916308

Date: 23-Oct-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 40 ea	Part: 647.1610 ✓ Wiper Deflector Fwd Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23811 PO: PO041133 ✓ Rev: A Line: 2	DAS 38 9-89	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>23/10/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

Made in Canada.

